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भाग 1 अल्प सतत चूड़ीदार परिसज्जा

(दूसरा पुनरीक्षण)

Indian Standard

DIMENSIONS FOR NECK FINISHES

PART 1 SHALLOW CONTINUOUS THREAD FINISH

(Second Revision)

UDC 621·798·147 : 666·171·92 : 006·78

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

December 1992 **Price Group 2**

Glassware Sectional Committee, CHD 010

FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Glassware Sectional Committee had been approved by the Chemical Division Council.

A variety of glass finishes are now being produced by the glass containers industry. Most of these finishes are being used by packers who have facilities for high speed filling and capping operations. Consequently it has become necessary to standardize the dimensions of different types of glass finishes.

This standard was first published in 1979 entitled 'Summary sheet on glass container neck finishes'. As the standard mainly prescribed the dimensions for various types of neck finishes for glass containers, the title of the standard was modified as 'Dimensions for neck finishes' during the first revision in 1986. Based on the experience gained and changes in the industry, standard was revised in 1986 into following eight parts:

Part 1 Shallow continuous thread finish (R 3)
Part 2 Shallow continuous thread finish for deep screw caps (R 3/D)
Part 3 Roll-on thread non-pilfer-proof (RONPP) finish
Part 4 Roll-on sealed thread pilfer-proof finish
Part 5 Vial Goldie seal glass finish
Part 6 Dual neck finishes
Part 7 Crown finish
Part 8 Vacuum lug finish

In the present revision, the values of some parameter have been upgraded as neck-rings are seldom used for the second time for the sake of quality.

While preparing this standard assistance has been derived from the following standards:

BS 1918 (Part 1) : 1978 Glass container finishes — Part 1 : Specification for continuous finishes. British Standards Institution.

GF 323 Specification for shallow continuous thread finish. Glass Manufacturers' Fed, UK.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

DIMENSIONS FOR NECK FINISHES

PART 1 SHALLOW CONTINUOUS THREAD FINISH

(Second Revision)

1 SCOPE

This Indian Standard (Second Revision) specifies dimensions for shallow continuous thread finish (R 3).

2 DIMENSIONS

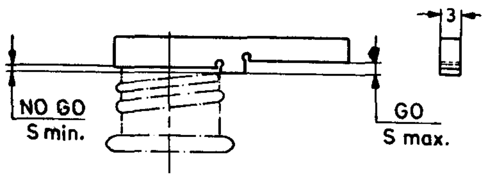
2.1 The dimensions of the shallow continuous thread finish shall be as given in Table 1.

2.2 Sealing Surface

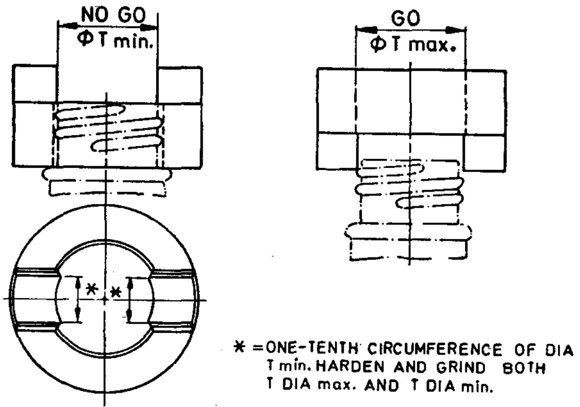
The sealing surface may be flat or radial and shall conform to the dimensions given in Table 1.

3 CHECKING AND INSPECTION

All essential dimensions may be ascertained by any appropriate method of measurement. However, a procedure of gauging and details of gauges are given in Fig. 1.

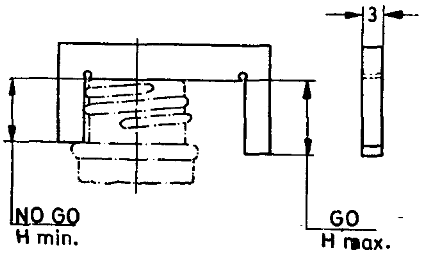


START OF THREAD GAUGE



* =ONE-TENTH CIRCUMFERENCE OF DIA T min. HARDEN AND GRIND BOTH T DIA max. AND T DIA min.

THREAD OUTSIDE DIA GAUGE



FINISH HEIGHT GAUGE

FIG. 1 GAUGES FOR SHALLOW CONTINUOUS THREAD FINISH

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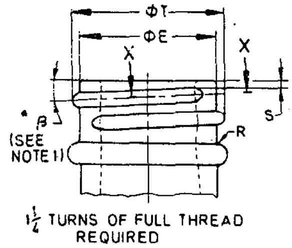
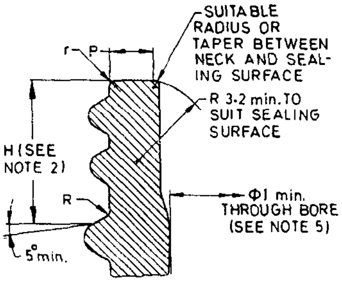
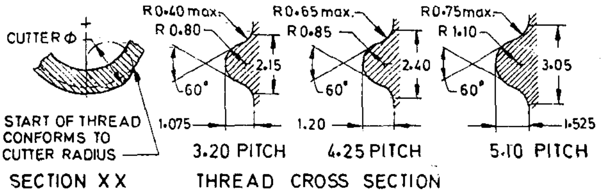
Table 1




SUITABLE RADIUS OR TAPER BETWEEN NECK AND SEALING SURFACE
r
P
R 3·2 min. TO SUIT SEALING SURFACE
H (SEE NOTE 2)
R
ΦI min. THROUGH BORE (SEE NOTE 5)
5° min.



No. of Size	T		E		H		I	R	S		P		r	β	Cutter Dia	Pitch
	Max	Min	Max	Min	Max	Min	Min	Max	Max	Min	Min		Max	Angle		
18	17·90	17·40	15·80	15·30	9·3	8·8	8·3	1·1	1·6	0·8	1·50		0·6	3°30′	9·5	3·20
20	19·90	19·40	17·80	17·30	9·3	8·8	10·3	1·1	1·6	0·8	1·50		0·6	3°7′	9·5	3·20
22	21·90	21·40	19·80	19·30	9·3	8·8	12·3	1·1	1·6	0·8	1·60		0·7	2°49′	9·5	3·20
24	23·90	23·40	21·80	21·30	10·1	9·6	13·1	1·1	1·6	0·8	1·60		0·7	2°34′	9·5	3·20
28	27·65	27·00	25·25	24·60	10·1	9·6	15·6	1·2	1·6	0·8	1·60		0·7	2°57′	12.7	4·25
30	28·65	28·00	26·25	25·60	10·1	9·6	16·6	1·2	1·6	0·8	1·70		0·8	2°51′	12·7	4·25
33	32·15	31·50	29·75	29·10	10·1	9·6	20·0	1·2	1·6	0·8	1·70		0·8	2°31′	12·7	4·25
38	37·45	36·55	35·06	34·15	10·1	9·6	25·0	1·2	1·6	0·8	1·70		0·8	2°9′	12·7	4·25
40	40·10	39·20	37·70	36·80	10·1	9·6	NOT APPLICABLE	1·2	1·6	0·8	1·70		0·8	2°1′	12·7	4·25
43	41·95	41·05	39·55	38·65	10·1	9·6		1·2	1·6	0·8	1·70		0·8	1°55′	12·7	4·25
48	47·45	46·55	45·05	44·15	10·1	9·6		1·2	1·6	0·8	1·70		0·8	1°41′	12·7	4·25
51	49·95	49·05	47·55	46·65	10·4	9·6		1·2	1·6	0·8	1·70		0·8	1°36′	12·7	4·25
53	52·45	51·55	50·05	49·15	10·4	9·6		1·2	1·6	0·8	1·70		0·8	1°31′	12·7	4·25
58	56·45	55·55	54·05	53·15	10·4	9·6		1·2	1·6	0·8	2·00		0·9	1°25′	12·7	4·25
60	59·45	58·55	57·05	56·15	10·4	9·6		1·2	1·6	0·8	2·00		0·9	1°20′	12·7	4·25
63	62·45	61·55	60·05	59·15	10·4	9·6		1·2	1·6	0·8	2·00		0·9	1°16′	12·7	4·25
66	65·45	64·55	63·05	62·15	10·4	9·6		1·2	1·6	0·8	2·00		0·9	1°14′	12·7	4·25
70	69·45	68·55	67·05	66·15	10·4	9·6		1·2	1·6	0·8	2·00		0·9	1°7′	12·7	4·25
77	77·10	76·05	74·05	73·05	12·4	11·6		1·6	2·0	1·2	2·00		0·9	1°14′	12·7	5·10
83	83·00	82·00	80·00	79·00	12·4	11·6		1·6	2·0	1·2	2·00		0·9	1°9′	12·7	5·10
89	89·20	88·20	86·20	85·20	13·6	12·8		1·6	2·0	1·2	2·20		0·9	1°4′	12·7	5·10
100	100·00	99·00	97·00	96·00	15·2	14·4		1·6	2·0	1·2	2·20		0·9	0°56′	12·7	5·10
120	120·00	119·00	117·00	116·00	17·4	16·6		1·6	2·0	1·2	2·20		0·9	0°47′	12·7	5·10

NOTES

1 β—Helix angle or angle of fixture to cutter. $\tan \beta = \dfrac{\text{pitch}}{\pi\ (\text{mean between mean } T \text{ and mean } E)}$

2 *H* dimension represents distance from top of finish down to a point where line tangent to *T* intersects top of bead or shoulder.

3 All essential dimensions may be ascertained by any standard form of measurement except the *T* diameter which should be assessed by a Parnaby gauge.

4 Contour of bead is optional.

5 Not suitable for calculating insert dimensions.

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